

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021810**Date Inspected:** 03-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG, Steel Barrier**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW), Flux Cored Arc Welding (FCAW), and Submerged Arc Welding (SAW) processes.

ZPMC QC is identified as Zhan Hai Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Perimeter Plate (Saddle Housing)

PCMK: SA7005A-001

Weld Number: 002

Welder: 214945

WPS-B-P-2112-ESAB

Component: Deck Plate

PCMK: SEG3007

Weld Number: 007

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Welder: 058100
WPS-B-T-2221-B-L2c-S-2

Component: Edge Plate
PCMK: SEG3019N
Weld Number: 005
Welder: 044790
WPS-B-T-2233-ESAB

Component: Bottom Plate I rib
PCMK: SEG3019BB
Weld Number: 166
Welder: 054013
WPS-345-SMAW-3G-FCM-REPAIR
WR 20246
Photo Below

Component: Bottom Plate I rib
PCMK: SEG3019BB
Weld Number: 034
Welder: 044779
WPS-345-SMAW-3G-FCM-REPAIR
WR 20246

Bay 16

This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Shielded Metal Arc Welding (SMAW), And Flux Cored Arc Welding (FCAW) processes.
ZPMC QC is identified as Guo Xing Hui.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Component: Steel Barrier
PCMK: W2-SB16-003
Weld Number: 032~043
Welder: 201905
WPS-B-T-2113

Component: Steel Barrier
PCMK: W2-SB27-001
Weld Number: 084, 085
Welder: 201074
WPS-B-T-2132

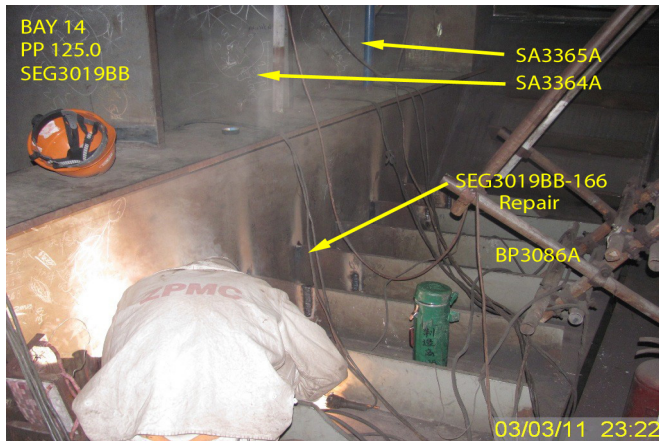
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Component: Steel Barrier
PCMK: E5-SB22-002
Weld Number: 53, 54
Welder: 201888
WPS-B-T-2132

Component: Steel Barrier
PCMK: W2-SB14A-001
Weld Number: 128, 129
Welder: 201889
WPS-B-T-2132

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Combs,Dennis

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer
